

Date: Friday, 10/13/2006 9:27:33 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
 Job Number : 28958
 Estimate Number : 10608
 P.O. Number : N/A Part Number : D2655
 This Issue : 10/13/2006 S.O. No. : N/A Drawing Number : D2655 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 28856 Material : N/A
 Due Date : 10/30/2006 Qty: 20 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature] 061013
 Comment : Est. D00.06.22 Removed P/O for powder coat EC
 Est Rev:E Now on Waterjet 06-10-04 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1018B400X250 Inventory



Comment: Qty.: 0.2835 f(s)/Unit Total: 5.6700 f(s)
 1018 ASTM A36 .250" thk bar x 4.0"
 Batch: M10237

2.0 WATER JET FLOW-WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2655
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

SAD 06/10/15 20

SAD 06/10/23 20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 06/10/15 20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06/10/16 20

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius
 2-Deburr any rough edges after tumbling

S.E 06/11/01 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 02/11/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:27:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 28958

Part Number: D2655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 06.11.01

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat per QSI 005 4.3.5.1

M101575

yl 06/11/02 x20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/11/02 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5140

6/11/02 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/03

Job Completion



U 06.11.03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

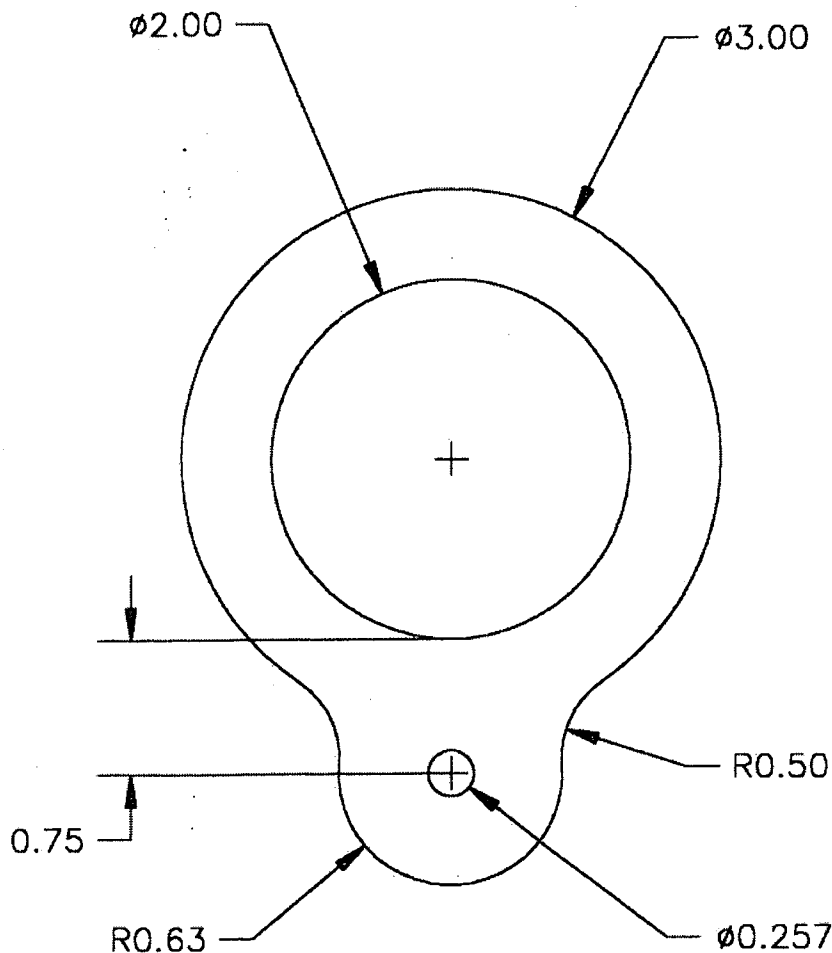
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED
47/07/14 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28958

NOTE: DEBURR ALL SHARP EDGES
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK
FINISH: POWDER COAT PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

